Each

Dart Aerospace Ltd. Monday, 1/8/2007 10:25:32 AM User: Kim Johnston **Process Sheet** : SPACER : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 30107 **Estimate Number** : 10001 : D2213 Part Number P.O. Number ·NIA S.O. No. : NA : 1/8/2007 **Drawing Number** D2213 REV B This Issue : N/A Prsht Rev. **Project Number** : What : MACHINED PARTS First Issue **Drawing Revision** : 30049 Material Previous Run 160 Um: : 1/30/2007 **Due Date** Qty: Written By Checked & Approved By Comment : Est Rev: C Jurned In-House 05-10-17 JLM **Additional Product** Job Number: **Machine Or Operation:** Description: Seq. #: M6061T6R0750 6061-T6 Round Bar .750" 1.0 Comment: Qty.: 1.1000 in(s)/Unit Total: 176.0000 in(s) MATERIAL:6061-T6 Round Bar .750" (M6061T6R0750) Batch: 103156 MS OTIONITY 2.0 Comment: HARDINGE CNC LATHE SMALL 1-TURN AS PER FOLIO FA113 & DWG D2213, FOLIO REV: A DWG REV: B 2-DEBURR AS REQUIRED INSPECT PARTS AS THEY COME OFF MACHINE QC2 3.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8

> Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1

Comment: SECOND CHECK HAND FINISHING1

HAND FINISHING RESOURCE #1



5.0

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W/O:		WORK ORDER CHANGES							
DATE	STEP PROCEDURE CHANGE		Ву	By Date		Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No:	PAR #:	Fault Category:	 NCR: Yes No	DQA:	Date:	OHOLLE
			QA: N/C C	losed:	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC	Corrective Action Section B			Verification	Varification Approval	Annewal	
DATE	STEP	Section A	Initial Chief Eng			Section C	Approval Chief Eng	Approval QC Inspector	
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NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:25:32 AM Kim Johnston User: **Process Sheet** Drawing Name: SPACER Customer: CU-DAR001 Dart Helicopters Services Job Number: 30107 Part Number: D2213 Job Number: Seq. #: Description: **Machine Or Operation:** INSPECT POWDER COAT/CHEMICAL CONVERSION 6.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_ QC21 8.0 Comment: FINAL INSPECTION/W/O RELEASE U 07.11.18 Job Completion

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W/O:		WORK ORDER CHANGES						
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	•	PAR #· Fault Category:	NCR: Yes	No DO	Δ.	Date:		

Part No:	PAR #:	Fault Category:	NCR: Yes N	o DQA:_	Date: _	
			QA: N/0	C Closed: _	Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B		Verification	A	Approval		
DATE	STEP	STEP Section A Initial Chief Eng		Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
						,			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30107
Description: Spacer	Part Number:	D2213
Inspection Dwg: D2213 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.990	+0.010/-0.000	. 995				
0.750	+/-0.005	.748				
0.650	+/-0.005	,653				
Ø0.194	+0.005/-0.000	195		·		
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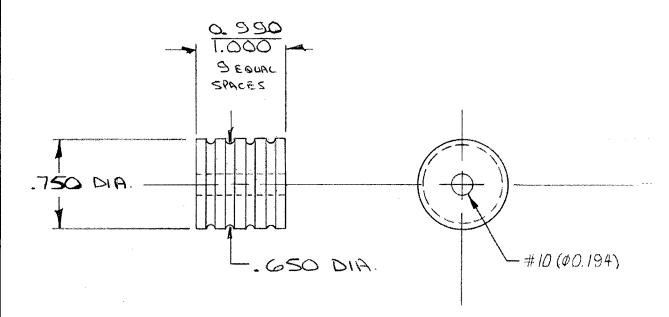
Measured by:	Audited by:	22	Prototype Approval:	N/A
Date: 07/01/17	Date:	04.01.17	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	05.02.17	New Issue	KJ/JLM	Cidl
			70	





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	DESIGN		DRAWING NO.	REV. B
!		0.5. De 73.00	D2213	SHEET OF
	STRESS		TITLE	
			SPACER	
	B	95:08:17	#10 HOLE ADDED	



MATERIAL ALUMINUM ALLOY ZOII-T3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER